providing a wrapper dispensing system for dispensing wrapping onto a roll of web material, said wrapper dispensing system comprising a wrapper dispensing station and a wrapper dispensing means,

supporting a roll of web material on a roll rotation station,

rotating said roll rotation station with said roll of web material supported thereon, said wrapper dispensing system remaining stationary relative to said rotating supported roll,

dispensing wrapping onto the rotating supported roll from said wrapper dispensing station via said dispensing means so that the wrapping is wound so as to form on said rotating supported roll either a centered wrapping or a stagewise overlapping wrapping, and

moving the roll rotation station laterally in the axial direction of the rotating supported roll relative to the wrapper dispensing system during the dispensing step.

2. (previously presented) A method according to claim 1, wherein the wrapping is wound in a slightly helical manner onto the roll.

3. (previously presented) A method according to claim 2, wherein layers of wound wrapping have sharp edges that are aligned partially or entirely overlapping so that a staggered stepped bond can be formed thereberween.

4. (previously presented) A method according to claim 2 or 3, wherein the slightly helical manner by which the wrapping is wound is performed by the movement of the roll rotation station laterally relative to the wrapper dispensing system during the wrapping dispensing operation.

5. (previously presented) A method according to claim 4, wherein the wrapping is aligned in a slightly helical position in regard to the roll rotation station.

6. (previously presented) A method according to claim 1, further comprising the step of, after the dispensing step, wherein the wrapping being dispensed is a stagewise overlapping paper